

# Work Order ID 78490

**\*78490\***

Page 1

January-10-12 1:14:42 PM

Item ID: D206-667-203

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Crosstube Aft

Start Date: 1/10/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: **Rework**

Approvals: Process Plan: *U*

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-667-243	Rev C (DEO)
DSI9565	A

100

0.00

**\*100\***

DOCUMENT CONTROL *SP*

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-203 CHG004

*12.01.25*

101

0.00

**\*101\***

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK:  
1 X D206-667-203BL B71045

DISASSEMBLE CLAMPS, PUT ASIDE TO REASSEMBLE

STRIP TUBE ENTIRELY

*1/12 12-01-16*

<b>DART</b> Dart Aerospace Ltd. 1270 ABBOTTEN ST HAWKESBURY ON CANADA K6A 1K7				TC APPROVAL #09-89 TEL: 1-613-632-5200	
P/N	D206-667-203BL	CHG	CHG004		
DESC	Crosstube Aft High	STC	SH01-5		
LOT	B71045	STC	SR01304NY		
MODEL	Bell 206L/L1/T3/L4	STC			
MADE IN CANADA 02/23-1					

**Work Order ID 78490****\*78490\***

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Item ID: D206-667-203

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Crosstube Aft

Start Date: 1/10/12

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/13/12

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	SprayPaint	0.00							
<b>*200*</b>									
SprayPaint	<b>Memo</b>	0.00							
Spray Painting	1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2  PRIME: Start Time: <u>11:00</u> Finish Time: <u>11:45</u>  PAINT: Start Time: <u>3:45</u> Finish Time: <u>4:45</u>								
				1A8 12-01-17					
210	QC14- Inspect Spray Paint	0.00							
<b>*210*</b>									
QC	<b>Memo</b>	0.00							
Quality Control	Wrap in plastic bag to protect from scratches			S 12/01/12					

# Work Order ID 78490

**\*78490\***

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Item ID: D206-667-203

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Aft

Stop

**\*NS2\***

Start Date: 1/10/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

0.00

**\*220\***

Crosstubes

0.00

Crosstubes

Crosstubes

**Memo**

1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe

2-Install supports with Proseal 890 per DSI9565 and QSI 015  
A/R Proseal 890 Batch: \_\_\_\_\_

3- Torque bolts as per dwg

4-Install nut plates as per Dwg D206-667-243.

*1/12 12-01-23*

*SP 12-01-25*

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

**Memo**

0.00

Quality Control

*8/2/12/24*

# Work Order ID 78490

**\*78490\***

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Item ID: D206-667-203

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Aft

Start Date: 1/10/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

USE ORIGINAL KIT

SP 12-01-25

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

12-01-25 (1)

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

REPACKAGE USING NEW B/N  
Identify and pack for shipping as per PPP D206-667-203

Location: E  
PPP Rev: E

SP 12-01-25 -

**Work Order ID 78490****\*78490\***

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Item ID: D206-667-203

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Aft

Start Date: 1/10/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

12/1/30  
012-0126

January-10-12 1:14:41 PM

**Required Qty: 1.00**

**Comments:** IPP Rev:F 05.09.01 Add holes for compatibility with Bell SkidtubesKJ/JLM  
IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec  
IPP Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC  
IPP Rev:I 08-12-15 add magnobond DD verified by:EC  
IPP Rev J 09.01.06 ECN 08-562 EC verified by:DD IPP REV:K 11.08.05 PER ECN 11-615 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A Bolt		Purchased	No			250	Each	634.0000	10	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		634							
				118191		80							
				119547		454							
				119981		100							
AN5-32A Bolt		Purchased	No			250	Each	215.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST339		215							
				118422		2							
				118628		38							
				118983		25							
				119328		100							
				119862		50							
AN5-34A Bolt		Purchased	No			250	Each	64.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST339		64							
				117794		34							
				119328		30							
AN960JD516 Washer	NAS1149D0563J	Purchased	No			250	Each	0.0000	18	18			

# Picklist Print

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Page 2

Work Order ID: 78490

Parent Item: D206-667-203

Parent Item Name: Crosstube Aft

Start Date: 1/10/12

Required Date: 1/13/12

Start Qty: 1.00

Required Qty: 1.00

D206-667-203BL Manufactured No Each 2.0000  
Crosstube Aft, Blue

1 71045 u

Location	Loc Qty	Loc Code
FG114	2	
71044	1	
71045	1	

~~D206-667-203TRN~~ Manufactured No Each 2.0000  
Crosstube Turning Detail

1 1

Location	Loc Qty	Loc Code
LG	2	
75011	1	
75012	1	

D2873-043 Manufactured No Each 34.0000  
Nut Plate Assembly

2 2

Location	Loc Qty	Loc Code
LG052	34	
72644	2	
73605	12	
75010	20	

D2873-045 Manufactured No Each 27.0000  
Nut Plate Assembly

2 2

Location	Loc Qty	Loc Code
LG052	27	
73529	7	
74985	20	

D2892-1 Manufactured No Each 18.0000  
Support

2 2

Location	Loc Qty	Loc Code
LG052	18	
72483	14	
72585	4	

70735 u

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Shop Packet Print

Page 2

# Picklist Print

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Page 3

Work Order ID: 78490

Parent Item: D206-667-203

Parent Item Name: Crosstube Aft

Start Date: 1/10/12

Required Date: 1/13/12

Start Qty: 1.00

Required Qty: 1.00

D3595-063-450

RUBBER CUSHION

Manufactured No

220

Each

74.1095

4

4

Location

Loc Qty

Loc Code

MAT052

74.109474

67353

2

68893

6

70113

0.56

71354

0.2

74113

0.349474

75597

65

70113 u

MS20601-AD4W10

RIVET

Purchased

No

220

Each

165.0000

14

14

Location

Loc Qty

Loc Code

LG051

165

118675

65

119386

100

117676 u

MS21042L5

Nut

Purchased

No

250

Each

2,022.0000

4

1116548 SD

12-01-25

Location

Loc Qty

Loc Code

ST300

2022

116105

5

116548

43

117611

50

118179

424

119109

1500

MS21920-22

Clamp(per MIL-DTL-8783C)

Purchased

No

220

Each

76.0000

4

4

Location

Loc Qty

Loc Code

LG

50

119545

50

LG050

26

116207

7

117506

1

118186

18

117506 u

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Shop Packet Print

Page 3



Item	Qty	Part Number	Description
	-243		
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER  
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE  
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE  
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

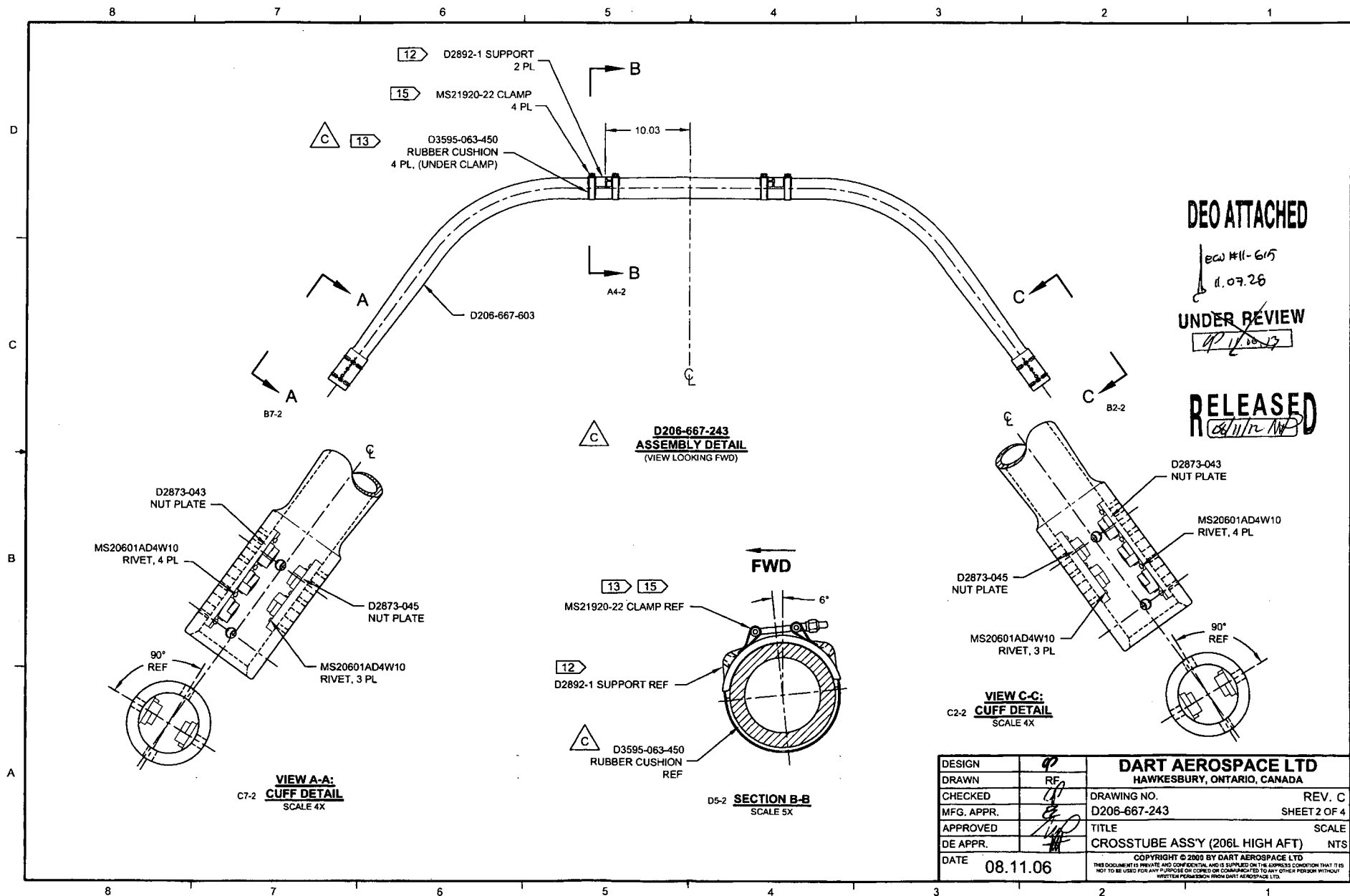
DEO ATTACHED

ECO #11-615  
11.07.26

UNDER REVIEW

RELEASED  
08/11/17

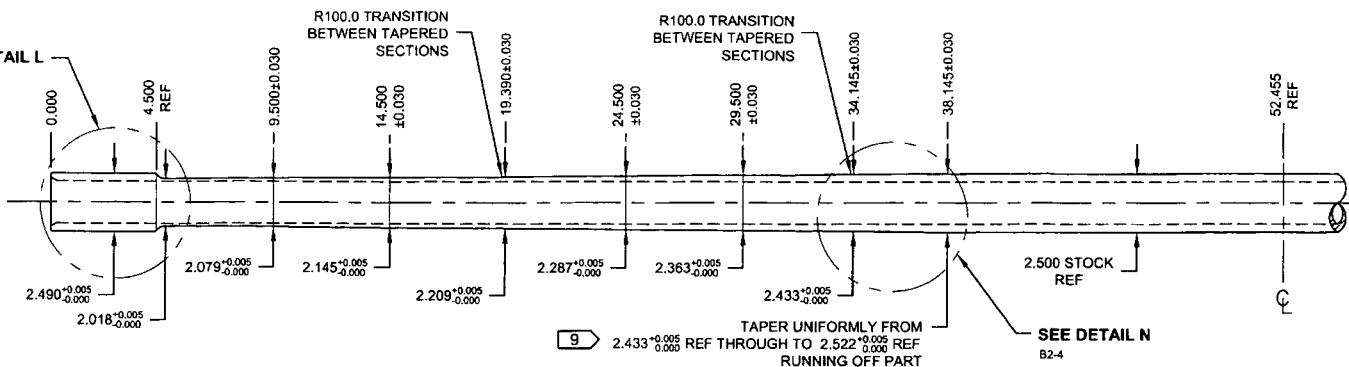
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2892-400-773 (ZN D8-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-243	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



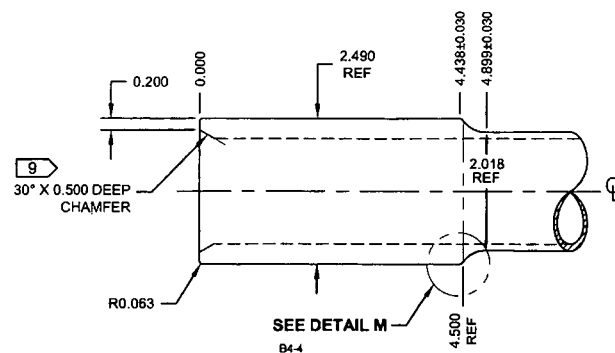
DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-243	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



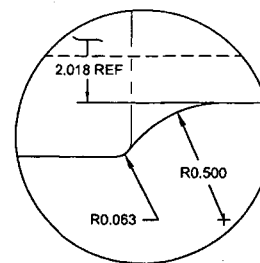
SEE DETAIL L  
B7-4



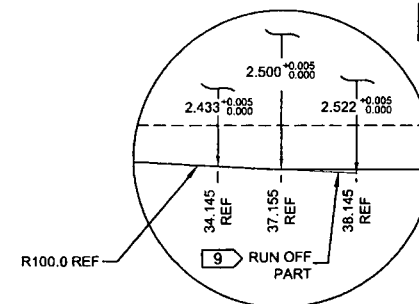
**TURNING DETAIL**



**DETAIL L: CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

BCW #11-615  
11.07.28

UNDER REVIEW

DEO ATTACHED

**RELEASED**

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. C
MFG. APPR.	90	D206-667-243	SHEET 4 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DRAWING NO. D206-667-243	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	REV. C	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D206-667-243-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>ADS</i>	MFG. APPR. <i>RS</i>	APPROVED <i>MD</i>	DE APPR. <i>#</i>			
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11.07.21			

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL.

**CHANGE:**

IS:

Item	Qty -243	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
2011-07-28  
*MD*

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# Work Order ID 83495

April-19-12

Page 1

Item ID: D206-667-203

Revision ID:

Item Name: Crosstube Aft

Draw Nbr: DSI9565

Start Date: 4/19/12

Start Qty: 1.0000

Revision Nbr A

Required Date: 4/19/12

Reqd Qty: 1.0000

Reference: to correct cost and pull BL

Cust Item ID:

Customer ID:

Description:

Sales Order:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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SCAN w/ 78490

U 12-21-19

# Picklist Print

April-19-12 9:02:30 AM

Page 1

Work Order ID: 83495

Parent Item: D206-667-203

Parent Item Name: Crosstube Aft

Start Date: 4/19/12

Required Date: 4/19/12

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:F 05.09.01 Add holes for compatibility with Bell SkidtubesKJ/JLM  
IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec  
IPP Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC  
IPP Rev:I 08-12-15 add magnobond DD verified by:EC  
IPP Rev J 09.01.06 ECN 08-562 EC verified by:DD IPP REV:K 11.08.05 PER ECN 11-615 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-667-203

Manufactured No

Each 10.0000

1

Crosstube Aft

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
36977	1	
36979	1	
51940	1	
74565	1	
FG063	6	
70720	1	
70721	1	
74563	1	
74564	1	
78490	1	
78491	1	

D206-667-203BL

Manufactured No

Each 0.0000

1

Crosstube Aft, Blue

78490

83493

Work Order ID 78490

\*78490\*

Page 1

January-10-12 1:14:42 PM

Item ID: D206-667-203

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Crosstube Aft

Stop \*NS2\*

Start Date: 1/10/12 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 1.00

\*1\*

Customer:

Reference: Rework

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-667-243	Rev C (DEO)
DSI9565	A

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-203 CHG004

12.01.25

101

0.00

\*101\*

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK:  
1 X D206-667-203BL B71045

DISASSEMBLE CLAMPS, PUT ASIDE TO REASSEMBLE

STRIP TUBE ENTIRELY

1A3 12-01-16

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST HAWKESBURY ONT CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-682-5200	
PIN	D206-667-203BL	CHG	CHG004		
DESC.	Crosstube Aft High	STC	SH01-5		
LOT	B71045	STC	SR01304NY		
MODEL	Bell 206L/L1/L3/L4	STC			
MADE IN CANADA					



# List Lots

April-12-12 7:21:00 AM

Page 1 of 1

Criteria : Item ID: d206-667-203bl All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D206-667-203BL Crosstube Aft, Blue	Main Warehouse FG114	71044	9/21/11	1.0000		QC21	CHG004	
	Main Warehouse FG114	71045	9/21/11	1.0000		QC21	CHG004	
Total:				2.0000				

78490  
78491

83495  
83496